



U.S. Department
of Transportation

400 Seventh Street, S.W.
Washington, D.C. 20590

**Pipeline and
Hazardous Materials
Safety Administration**

AUG 31 2005

DOT-E 12855
(SIXTH REVISION)

EXPIRATION DATE: July 31, 2007

1. GRANTEE: KRATON Polymers U.S. LLC
Belpre, OH
2. PURPOSE AND LIMITATION:
 - a. This exemption authorizes one-way transportation in commerce of non-DOT specification pressure vessels (stainless steel heat and/or carbon steel heat exchangers) containing the residue of a Class 3 material by highway motor vehicle. This exemption provides no relief from the Hazardous Materials Regulations (HMR) other than as specifically stated herein.
 - b. The safety analyses performed in development of this exemption only considered the hazards and risks associated with transportation in commerce.
3. REGULATORY SYSTEM AFFECTED: 49 CFR Parts 106, 107 and 171-180.
4. REGULATIONS FROM WHICH EXEMPTED: 49 CFR § 173.240 in that a non-DOT specification pressure vessel (stainless steel and/or carbon steel heat exchanger) is not authorized for transportation except as specified herein; and § 172.302(c) in that the marking requirements are waived.
5. BASIS: This exemption is based on the application of KRATON Polymers U.S. LLC, dated August 1, 2005, submitted in accordance with § 107.109.

AUG 31 2005

6. HAZARDOUS MATERIALS (49 CFR § 172.101):

Proper Shipping Name/ Hazardous Materials Description	Hazard Class/ Division	Identi- fication Number	Packing Group
Flammable liquids, n.o.s. *	3	UN1993	II
Flammable liquids, corrosive, n.o.s. *	3	UN2924	II

* Technical name must be added as required by 49 CFR 172.203(k).

7. SAFETY CONTROL MEASURES:a. PACKAGING - Prescribed packagings are:

- (1) Non-DOT specification "U" stamped pressure vessels (stainless steel heat exchangers) that are constructed in accordance with Section VIII Division 1 of the ASME Code. Each pressure vessel must have been successfully hydrostatically tested to no less than 50 psig.
- (2) Non-DOT specification pressure vessels (carbon steel shipping tubes) that are constructed in accordance with Section VIII Division 1 of the ASME Code. Each pressure vessel must have been successfully hydrostatically tested to no less than 50 psig.
- (3) When no corrosive residue is present, tube bundles that have been thoroughly steamed and/or purged with hot nitrogen to remove any free flowable hydrocarbon may be securely wrapped in tarps for shipment.

b. OPERATIONAL CONTROLS -

- (1) A positive nitrogen atmosphere, not to exceed 10 psig, must be maintained in the shell of each pressure vessel.
- (2) Authorization is for the transportation of non-DOT specification pressure vessels (stainless steel/carbon steel heat exchangers) from Belpre, OH to Dunn Heat

AUG 31 2005

Exchangers, Texas City, TX, for cleaning and decontamination.

(3) Only a contract carrier under the exclusive use of the shipper may be used.

(4) Each pressure vessel must be secured to the motor vehicle in accordance with the requirements of §§ 393.100 through 393.106.

8. SPECIAL PROVISIONS:

a. A current copy of this exemption must be maintained at each facility where the package is offered for transportation.

b. The marking requirement of § 172.302(c) is waived. The exemption number "DOT-E 12855", must appear on the shipping papers.

9. MODES OF TRANSPORTATION AUTHORIZED: Motor vehicle.

10. MODAL REQUIREMENTS: A current copy of this exemption must be carried aboard each motor vehicle used to transport packages covered by this exemption.

11. COMPLIANCE: Failure by a person to comply with any of the following may result in suspension or revocation of this exemption and penalties prescribed by the Federal hazardous materials transportation law, 49 U.S.C. 5101 et seq:

- o All terms and conditions prescribed in this exemption and the Hazardous Materials Regulations, 49 CFR Parts 171-180.
- o Persons operating under the terms of this exemption must comply with the security plan requirement in Subpart I of Part 172 of the HMR, when applicable.
- o Registration required by § 107.601 et seq., when applicable.

Each "Hazmat employee", as defined in § 171.8, who performs a function subject to this exemption must receive training on the requirements and conditions of this exemption in addition to the training required by §§ 172.700 through 172.704.

No person may use or apply this exemption, including display of its number, when this exemption has expired or is otherwise no longer in effect.

12. REPORTING REQUIREMENTS: Shipments or operations conducted under this exemption are subject to the Hazardous Materials Incident Reporting requirements specified in 49 CFR §§ 171.15 - Immediate notice of certain hazardous materials incidents, and 171.16 - Detailed hazardous materials incident reports. In addition, the grantee(s) of this exemption must notify the Associate Administrator for Hazardous Materials Safety -- OHMEA, in writing, of any incident involving a package, shipment or operation conducted under terms of this exemption.

Issued in Washington, D.C.:

Robert A. McGuire

607 Robert A. McGuire
Associate Administrator for
Hazardous Materials Safety

AUG 31 2005
(DATE)

Address all inquiries to: Associate Administrator for Hazardous Materials Safety, Pipeline and Hazardous Materials Safety Administration, Department of Transportation, Washington, D.C. 20590. Attention: PHH-31.

Copies of this exemption may be obtained by accessing the Hazardous Materials Safety Homepage at <http://hazmat.dot.gov/exemptions> Photo reproductions and legible reductions of this exemption are permitted. Any alteration of this exemption is prohibited.

PO: SS/dl/kah